

Date: Friday, 13/06/2008 10:46:03 AM
User: Julie Lecocq

Process Sheet

Shp 24/07

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L AFT X-TUBE
Job Number	: 39853	Part Number	: D206667203BL
Estimate Number	: 10973	Drawing Number	: D206-667-243 REV B + DSI 9415 ^{REV} 08.06.13
P.O. Number	:	Project Number	: N/A
This Issue	: 13/06/2008 S.O. No. :	Drawing Revision	:
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LANDING GEAR	Due Date	: 30/06/2008 Qty: 1 Um: Each
Previous Run	: 34483		
Written By	:		
Checked & Approved By	: <u>JP 08.6.13</u>		
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC



DOCUMENT CONTROL

08/06/08



08.6.16

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002 CHG 003 + DSI 9415 ^{REV} 08.06.13

2.0

D6004115

Crosstube Material



D206-667-203 TRN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube

Check OD = 2.500"; ID = 1.800"

B37987 CR 8-6-17

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L AFT X-TUBE

Job Number: 39853

Part Number: D206667203BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243
Inside of Cuff(Donot engrave on outside of tube)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

E2 8-6-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-203 BL PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 08/06/17
 QA: N/C Closed: _____ Date: _____

NCR: <u>39853</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.17	11	TUBE BENT HIGH Ø 23.688"	<p><i>GP</i></p> <p>08.06.17 pc QS1042</p>	<p>CUT CUFFS BY 1/8".</p> <p>Tube acceptable.</p>	<p><i>GP</i></p> <p>08.06.17 pc QS1042</p>	<p><i>GP</i></p> <p>08.06.17 pc QS1042</p>	<p><i>GP</i></p> <p>08.06.17 pc QS1042</p>	<p><i>GP</i></p> <p>08.06.17 pc QS1042</p>

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Drawing Name: 206L AFT X-TUBE

Job Number: 39853

Part Number: D206667203BL

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

JP 08.06.17

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.
- 2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.
- 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins
- 4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.
- 5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
- 6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.
- 7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.
- 8-C'sink holes as per Dwg D206-667-243.
- 9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

EL
4-6-18

IT 08-06-18

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 08-06-18

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/06/18 @

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/18 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 39853

Part Number: D206667203BL

Job Number:



Seq. #: Machine Or Operation: Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 6630

LPI as per ASTM 1417

C208106124 ①

Level 2 Attach copy of NDT results to work order

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

ml 08 06 24 ①

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 37341

ml 08 06 26

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 37941

ml 08 06 26

22.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet 107008

ml 08 06 26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206L AFT X-TUBE

Job Number: 39853

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

ml 08 06 26

24.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube DELFLEET BLUE

4-CLEAR WITH DELFLEET

ISSUE P.O TO ATELIER DEBOSSSELAGE

ml 08 06 24 (1)

25.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

080625

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400 (Cut to 7.73") Abrasion Strip

D3595-075-450 Rubber Cushion

PSI 9415 Ref 01.06.13

B 3895A ml 08 06 25

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support 39836

97

Ref 27.5
08.06.13

Magnabond 6398 B 107621

exp: 08/2009 ml 08 06 25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Drawing Name: 206L AFT X-TUBE

Job Number: 39853

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

107545

ml 08 06 25

29.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

magnabond

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

ml 08 06 25 (1)

2-Install supports and clamps as per Dwg D206-667-243: Torque clamps to 80-100 in lb

ml 08 06 26 (1)

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08 06 26 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 107013

50

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: 107939

8/6/26

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206L AFT X-TUBE

Job Number: 39853

Part Number: D206667203BL

Job Number:



Seq. #: Machine Or Operation: Description :

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

~~107013~~

107534

50

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

106519

50

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

107958

866128

50

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808/06/26

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

Rev D

CHG 003 08.06.13

808/06/26

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/26

Job Completion



08/06/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

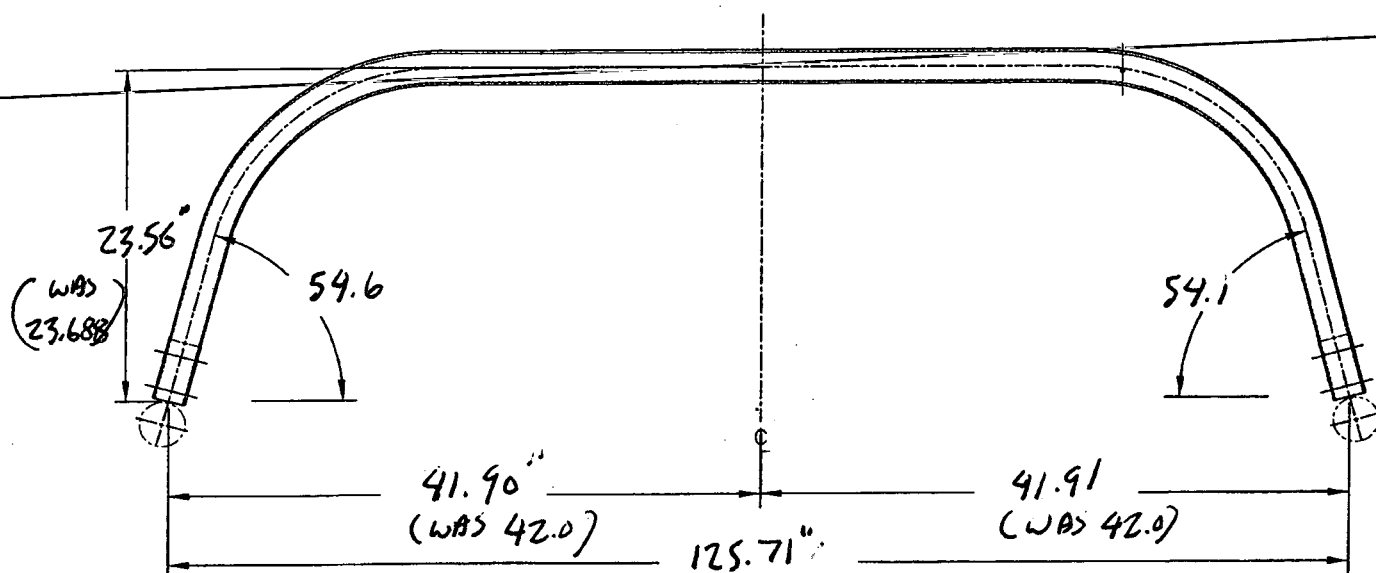
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39853
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
Tube bent high (23.688). CUT COFF TO DIMS SHOWN.

QC15 Inspection	08.06.17
Date	<i>CP</i>

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>af</i>	<i>fu</i>

DART AEROSPACE LTD		Work Order: 39853
Description: Crosstube Assembly		Part Number: D206-667-243
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000					
	2.018	+0.005/-0.000					
	2.079	+0.005/-0.000					
	2.145	+0.005/-0.000					
	2.209	+0.005/-0.000					
	2.287	+0.005/-0.000					
	2.363	+0.005/-0.000					
	2.433	+0.005/-0.000					
	0.200	+/-0.010					
	0.500 x 30°	+/-0.010					
	R0.063	+/-0.010					
	R0.500	+/-0.010					
	4.438	+/-0.030					
SIDE B	104.91	+/-0.020					
	2.490	+0.005/-0.000					
	2.018	+0.005/-0.000					
	2.079	+0.005/-0.000					
	2.145	+0.005/-0.000					
	2.209	+0.005/-0.000					
	2.287	+0.005/-0.000					
	2.363	+0.005/-0.000					
	2.433	+0.005/-0.000					
	0.200	+/-0.010					
	0.500 x 30°	+/-0.010					
	R0.063	+/-0.010					
	R0.500	+/-0.010					
	4.438	+/-0.030					

N/A
See w/o 37987

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 -HPH 08.06.13
UNDER REVIEW
06.08.10/PH
12-drum Detail F

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

4 D3595-075-450 Rubber Cushion

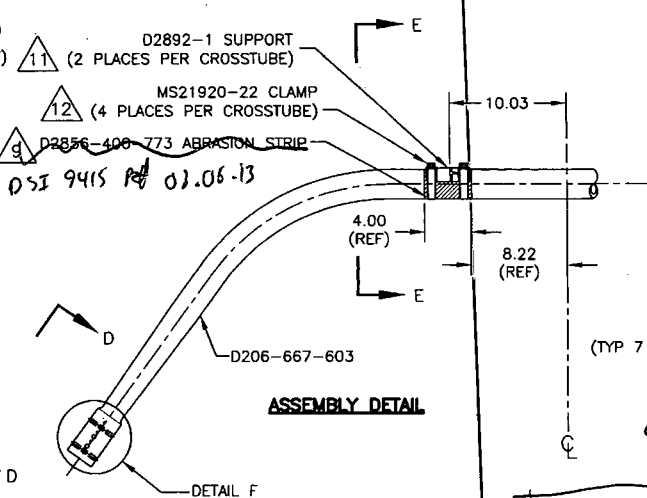
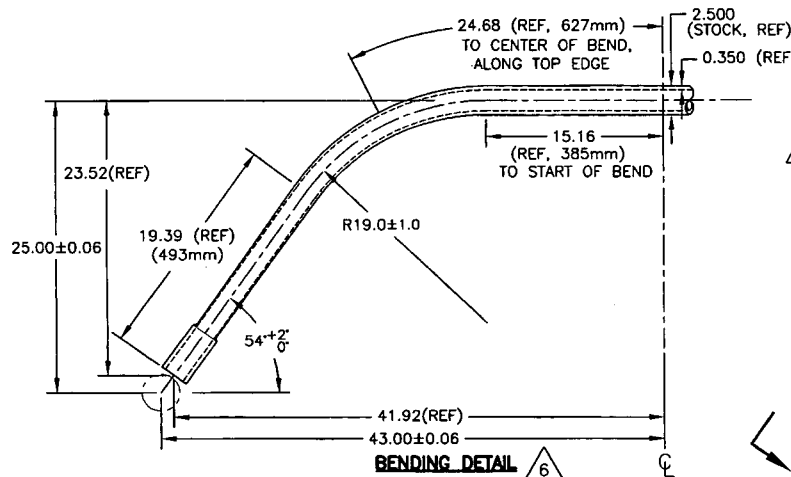
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL ~~D2856-400-773~~ ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPRORT, PER QSI 035. PH 08.06.13
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39853

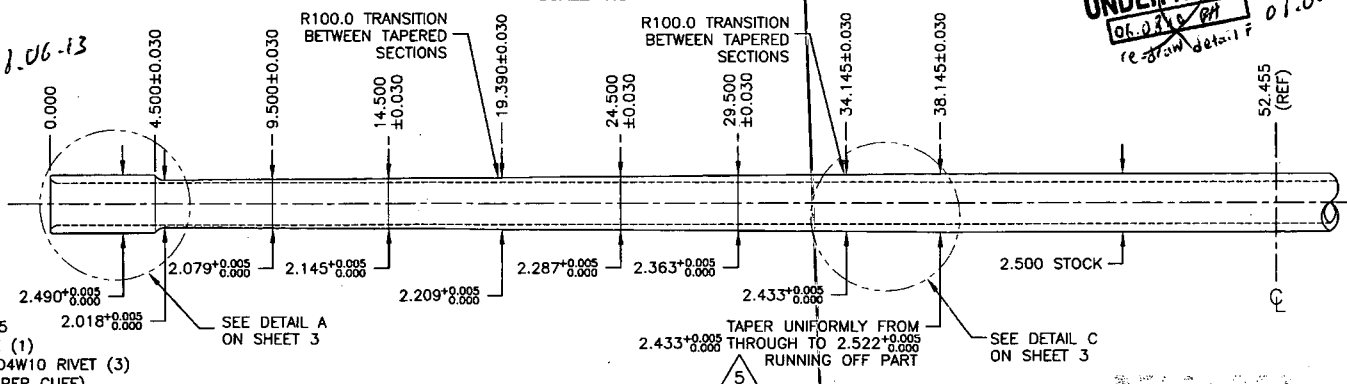
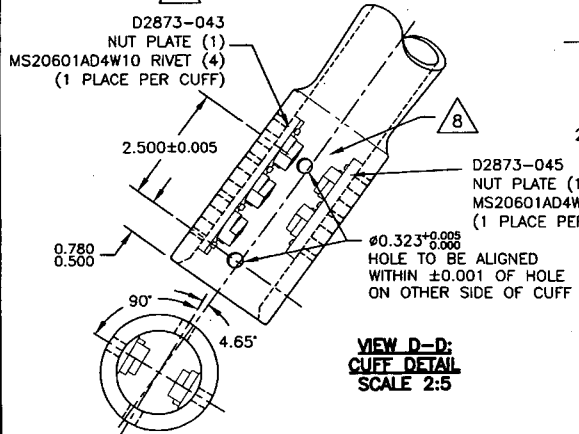
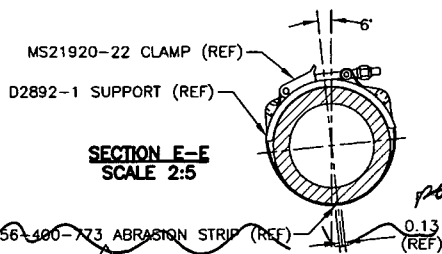
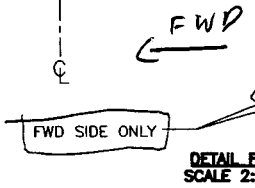
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$\triangle B$ $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

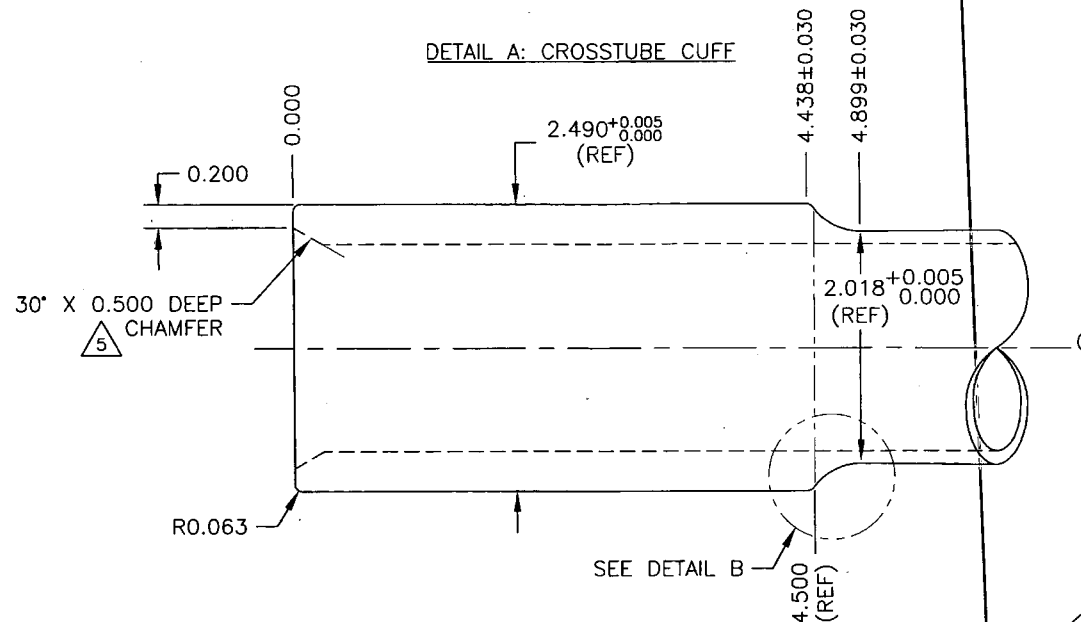


UNDER REVIEW
 $\phi 0.323$ PH
re-grow detail F
01.06.13

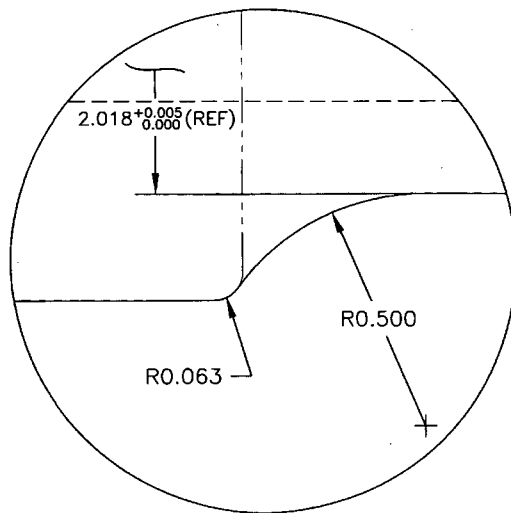
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WITHOUT NOTICE
WORK ORDER
NO. 39803

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		DATE	05.07.26			D206-667-243	SHEET 2 OF 3
		TITLE	CROSSTUBE ASS'Y (206L HIGH AFT)				
		SCALE	1:10				

DETAIL A: CROSSTUBE CUFF



PH 08.06.13
UNDER REVIEW
 06.05.10 PH
 re-draw detail F

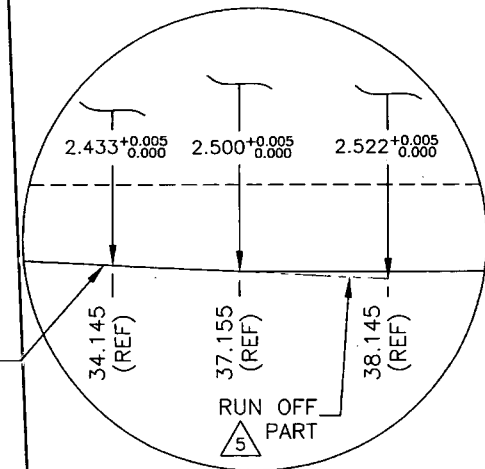


DETAIL B: CUFF TRANSITION SCALE 4:1

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DETAIL C: TAPER RUN-OFF NOT TO SCALE

R100.0 (REF)



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SHEET 3 OF 3

05.07.26

PH

TITLE

CROSSTUBE ASS'Y (206L HIGH AFT)

SCALE

1:1

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2

REF: CANADIAN STC: SH01-5
REF: FAA STC: SR01304NY

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For D206-667-101/-201/-103/-203 or D407-667-105 cross tubes at CHG 003 or later, the D2856-400-694/-773 abrasion strip has been removed, the center D2891-1 or D2892-1 support has been bonded onto the crosstube using Magnabond 6398 and D3595-075-395/-450 Rubber Cushions have been installed underneath the MS21920-20/-22 Clamps. Amend parts list of the IIN-D206-667 section 5 and ICA-D206-667 Section 32.8 as follows:

REMOVE:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
13	2	2	2		2	D2856-400-694	ABRASION STRIP
14				2		D2856-400-773	ABRASION STRIP

ADD:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
24	4	4	4		4	D3595-075-395	RUBBER CUSHION
25				4		D3595-075-450	RUBBER CUSHION

To prevent the supports from shifting on the D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 002 or earlier, the D2891-1/D2892-1 supports should be removed and re-installed as follows:

- Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- Remove the qty (2) MS21920-20/-22 clamps from the crosstube that fasten the D2891-1/D2892-1 supports to the crosstube.
- Remove the D2856-400-694/-773 abrasion strip from the crosstube per section 32.5 of ICA-D206-667.
- Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D206-667. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D206-667. Touch up finish per item 5.3.9 of the 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath the D2891-1/D2892-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1/D2892-1 support on the crosstube using MS21920-20/-22 Clamps. Install a D3595-075-395/-450 Rubber cushion underneath each MS21920-20/-22 Clamp. Torque clamps 80-100 in-lb. Let the D206-667-101/-201/-103/-203 or D412-667-105 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	HS	08.05.26
REV.	DESCRIPTION	BY	DATE
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CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	E	DSI 9415	SHEET 1 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	CROSSTUBE SUPPORT CHANGE	NTS
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7) Re-install the D206-667-101/-201/-103/-203 or D412-667-105 crosstube per section 32.2 of ICA-D206-667.

For customers who would like to upgrade their D206-667-101/-201/-103/-203 or D412-667-105 crosstubes from CHG 002 or earlier to CHG 003, the following kit can be obtained from Dart:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9415-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-101/-201/-103 OR D407-667-105)
	X	DSI 9415-013	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-203)
4		D3595-075-395	RUBBER CUSHION
	4	D3595-075-450	RUBBER CUSHION

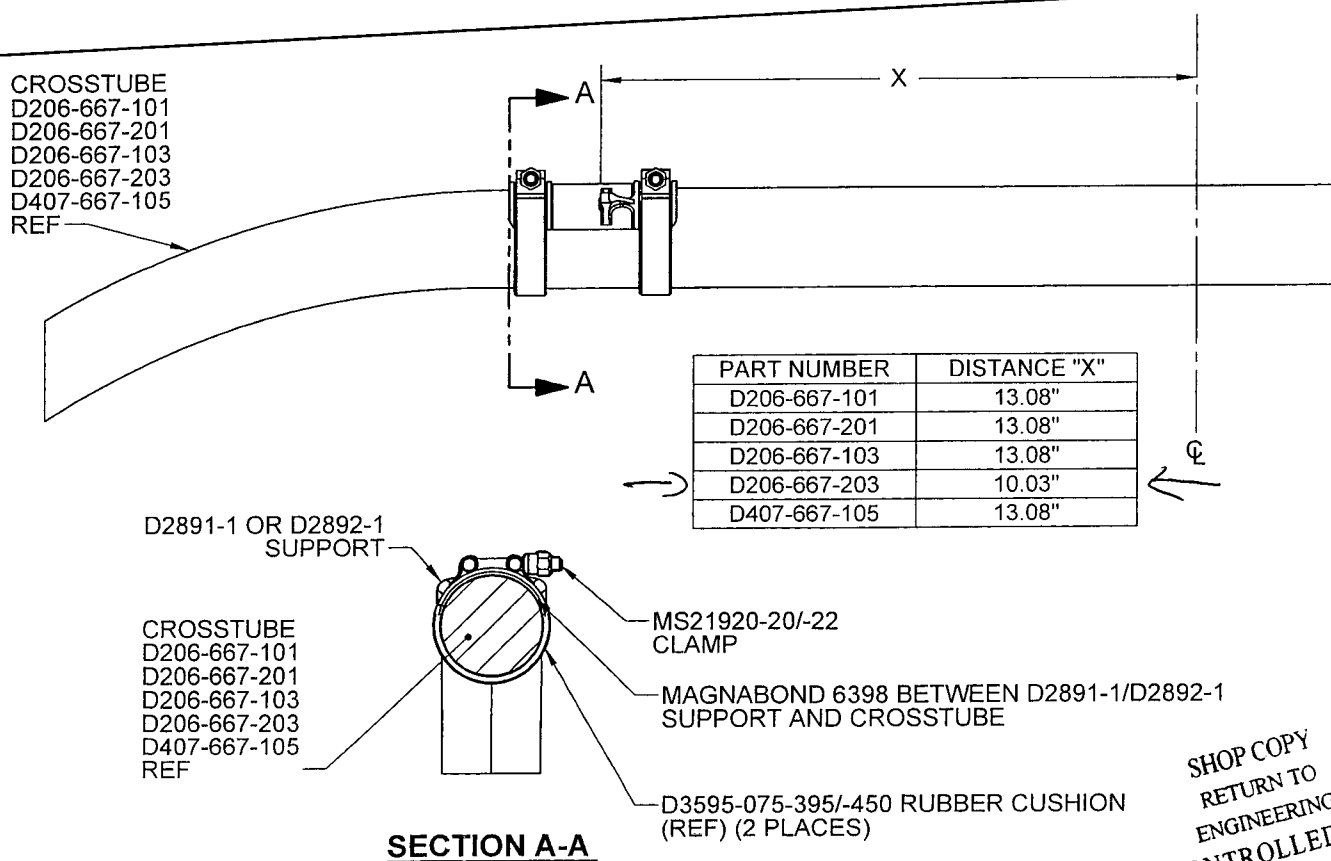


FIGURE 1 - CROSSTUBE SUPPORT

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

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MFG. APPR.	EZ		SHEET 2 OF 2
APPROVED	MP	TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS
DE APPR.	MP		
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